

Date: Wednesday, 1/9/2008 3:40:41 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SUPPORT GUSSET (350) BASKET
Job Number	: 36691		
Estimate Number	: 10496		
P.O. Number	: <i>N/A</i>	Part Number	: D2325
This Issue	: 1/9/2008	Drawing Number	: D2325 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>NA</i>	Drawing Revision	: B
Previous Run	: 35585	Material	: <i>N/A</i>
Written By	: <i>H 08.01.09</i>	Due Date	: 1/16/2008
Checked & Approved By	: <i>H 08.01.09</i>	Qty:	52 Um: Each
Comment	: Est. D 02.12.06 Reformat; Rev B KJ/RF Est. E 06.05.03 Water jet EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 .063 Sheet
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*30.0*

Comment: Qty.: 0.4883 sf(s)/Unit Total : 25.3890 sf(s)
304/316 SS .063 Sheet Batch: *106653 IB 8-1-14*

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
1-Cut as per Dwg D2325
Dwg Rev: *B*
Prog Rev: *B*

IB 8-1-11

2-Deburr if necessary *IB 8-1-11*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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*IB 8-1-11*

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*08/01/09**counts**(56)*

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr if necessary

aka Done at step 2.2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 08/04/14
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT GUSSET (350) BASKET

Job Number: 36691

Part Number: D2325

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JS. 08/01/11 (X56)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGIN

Identify and Stock

Location: FATD.

JS. 08/01/11 (X56)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

JS. 08/01/11 (X56)

Job Completion



JS. 08-01-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

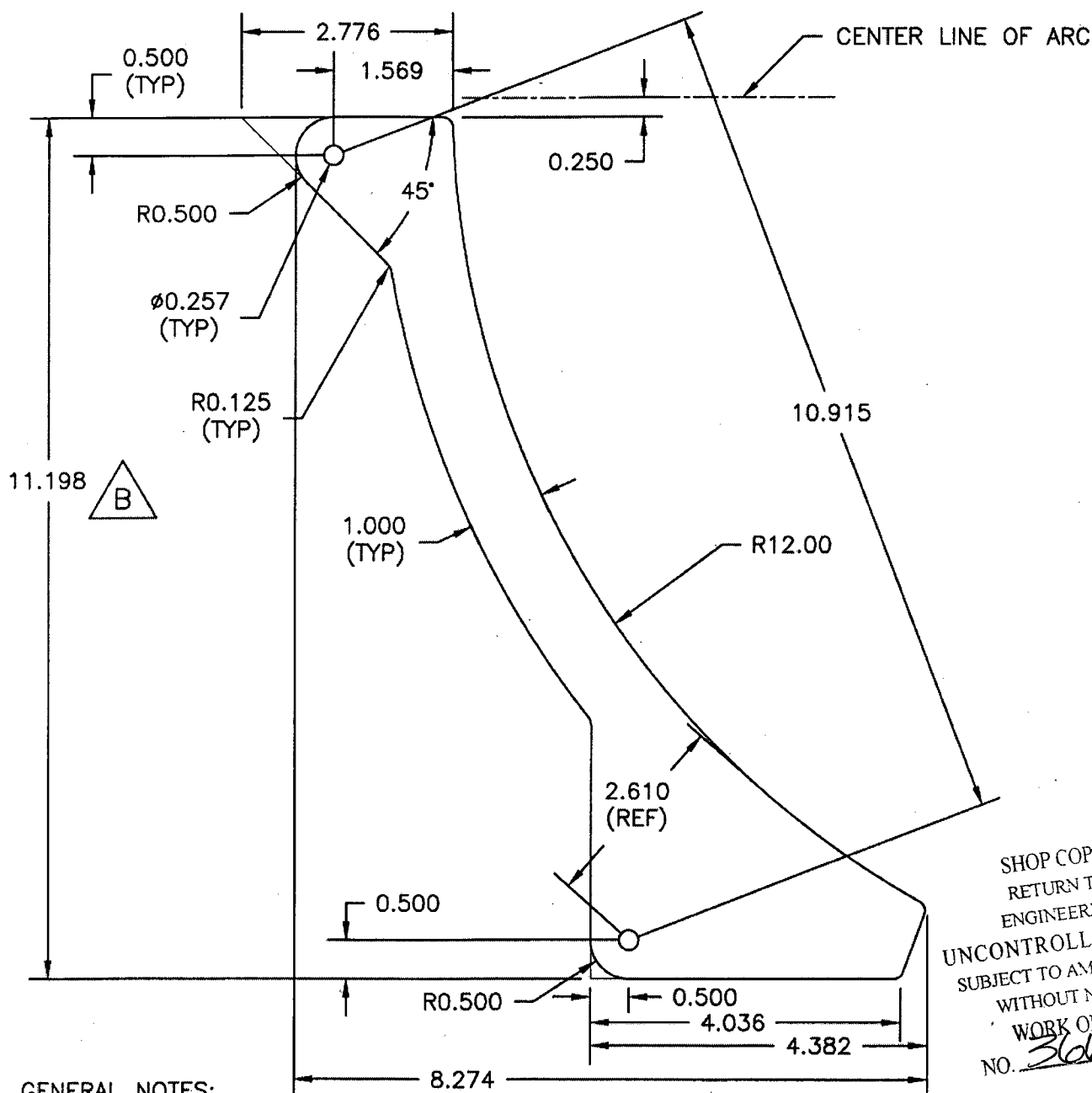
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN #	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2325	REV. B SHEET 1 OF 1
DATE 02.08.28		TITLE SUPPORT GUSSET	SCALE 1:2
A	94.12.13	NEW ISSUE	
B	02.08.28	REFORMAT; 11.198 WAS 11.948	

RELEASED
02.08.29 #



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36691

GENERAL NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.063 THICK (REF DART SPEC. M304S16GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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